

Work Order ID 153086***153086***

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Tuesday, November 08, 2016 10:52:05 AM

Item ID: DSI 9052-013 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: AS350/AS355 Basket/Pod Quick Release Pip Pins
Start Date: 11/4/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/8/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **NOV 09 2016** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9052	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL					DAS 27 9-89	DAS 21 9-89		16-11-30
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP 9052-013 CHG001								DEC 02 2016
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							NOV 30 2016
Packaging									28 39
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control						DAS 27 9-89			DEC 02 2016

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Item ID: DSI 9052-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AS350/AS355 Basket/Pod Quick Release Pip Pins

Start Date: 11/4/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/8/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D9052-013 Location: Fg123

0.00

0.00

DAS 27 9-89
DAS 28 9-89

DEC 02 2016

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.02

DAS 21 9-89

DEC 05 2016

16-12 02

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Picklist Print

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Work Order ID: 153086

153086

Parent Item: DSI 9052-013

DSI 9052-013

Parent Item Name: AS350/AS355 Basket/Pod Quick Release Pip Pins

Start Date: 11/4/2016

Required Date: 11/8/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A02.05.15New IssueNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
BLRS-010		Purchased	No			110	Each	13.0000	1	1			

RI RS-010

Quick Release Pin (1/4" x 1")

DAS
26
9-89

Location

Loc Qty

Loc Code

FG
121374
ST551
150058
ST557
150726

4
4
4
4
5
5

NOV 30 2016

BLRS-020

Purchased

No

110

Each

8.0000

3

3

RI RS-020

Quick Release Pin (1/4" x 1.5")

DAS
26
9-89

Location

Loc Qty

Loc Code

ST557
150059
150727

8
3
5

NOV 30 2016

DAS
28
9-89

DAS
28
9-89

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607 REV. F OR LATER REV.
(REF. CANADIAN STC: SH94-14, REF. FAA STC: SR00213NY)

AND TO AMEND INSTALLATION DRAWING D350-602 REV. E OR LATER REV.
(REF. CANADIAN STC: SH93-97, REF. FAA STC: SR01144NY)

**PURPOSE: TO ALLOW SUBSTITUTION OF THE BASKET/ POD ATTACHMENT BOLTS WITH QUICK
RELEASE PINS**

THE AN4-12A / AN4-15A / AN4-16A BOLTS USED ON D2230-1 CLAMPS MAY BE REPLACED WITH STAINLESS
STEEL POSITIVE LOCKING QUICK RELEASE PINS WITH A MINIMUM DOUBLE SHEAR STRENGTH OF 2400
LBS AND 0.25 INCH DIAMETER.

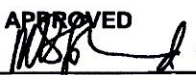
BOLT	MIN GRIP	POSSIBLE QUICK RELEASE PIN REPLACEMENT
AN4-12A	1.0"	AVIBANK: BLC4B10S, BLC4TA10S, BLC4R10S, BLC4LA10S MS NUMBER: MS17984C410, MS17985C410, MS17986C410, MS17987C410 REID: BLRS-010, BLBS-010
AN4-15A / AN4-16A	1.3"	AVIBANK: BLC4B13S, BLC4TA13S, BLC4R13S, BLC4LA13S MS NUMBER: MS17984C413, MS17985C413, MS17986C413, MS17987C413 REID: BLRS-020, BLBS-020

THE FOLLOWING OPTIONAL KITS ARE AVAILABLE FROM DART TO PROVIDE QUICK RELEASE CAPABILITY.
DART HELI-UTILITY-BASKETS™ D350-607-041 @ CHG 008, D350-607-043 @ CHG 005, D350-607-045 @ CHG
003, D350-607-047 @ CHG 003, OR LATER CHANGE NUMBERS, OR KITS MODIFIED PER SERVICE
INSTRUCTION DSI 9342 USE AN4-15A BOLTS AND SHOULD PURCHASE THE DSI-9052-013 KIT. EARLIER
CHANGE NUMBERS THAT HAVE NOT BEEN MODIFIED PER SERVICE INSTRUCTION DSI 9342 USE AN4-12A
BOLTS AND SHOULD PURCHASE THE DSI-9052-011 KIT.

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI-9052-011	QUICK RELEASE KIT, FOR D350-607-041 (CHG ≤007) / -043 (CHG ≤004) / -045 (CHG ≤002) / -047 (CHG ≤002)
	X	DSI-9052-013	QUICK RELEASE KIT, FOR D350-602-011/-013/-014 & D350-607-041 (CHG 008) / -043 (CHG 005) / -045 (CHG 003) / -047 (CHG 003)
4	1	BLRS-010	QUICK RELEASE PIN (1.0" GRIP)
	3	BLRS-020	QUICK RELEASE PIN (1.5" GRIP)

IT IS ACCEPTABLE TO LEAVE THE D2230-1/-3 CLAMPS INSTALLED ON THE CROSSTUBES WHEN THE
BASKET OR POD IS REMOVED. WEIGHT & BALANCE, FOR CLAMPS ONLY, IS 1.8lb (0.82kg) @ STA 135in
(3.43m) & BL ±36in (±0.91m).

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 09.06.23
CERT. NO.: SH94-14 / SH93-97
ISSUE NO.: 4 / 4

E	-013 KIT NOW APPLICABLE TO NEW D350-607 KITS	CP	09.06.23
D	ADD CLAMPS ONLY NOTE	KJ	04.03.23
C	ADD DSI 9052-013	CP	03.12.11
B	ADD PART NUMBERS	BW	96.11.13
A	NEW ISSUE	MM	96.11.04
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	ADS	DRAWING NO.	REV. E
MFG. APPR.	N/A	DSI 9052	SHEET 1 OF 1
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	QUICK PIN REPLACEMENT	NTS
DATE	09.06.23	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	